

# Work Order ID 50014

July 2, 2009 3:43:59 PM



Page 1

Item ID: D2224  
Revision ID: E  
Item Name: Rappel Anchor

Accept



Setup Start



Stop



Start Date: 07/06/2009 Start Qty: 10.00  
Required Date: 07/15/2009 Req'd Qty: 10.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2224	Rev E

100

0.00



BAND SAW

Bandsaw

0.00

Jeaspa Bandsaw

*DJP 09/07/06*

Memo

Cut blanks: 2.8" \*\*\*\*\*Note grain direction \*\*\*\*\*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

HAAS CNC vertical machine #1

*DJP 09/07/06*

Memo

1-Machine as per Folio D2224 & Dwg D2224| I2-Deburr & Tumble

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

Quality Control

*DJP 09/07/06*

Memo

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

⇒ 50607109

(10)

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: 10059 Red Anodize as per Dwg D2224 MIL-A-8625

CY 09/07/13 10

150

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Pc 9/7/22 (10)

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

INSPECT ANODIZE

170

Identify as per dwg & Stock Location: 489

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27  
W 9-07-24

# Picklist Print

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Page 1

Work Order ID: 50014

Parent Item: D2224RevE

Parent Item Name: Rappel Anchor

Comments:

Start Date: 07/06/2009

Required Date: 07/15/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased	No			100	f	5.3300	2.3263			



7075-T73 Bar 2.50 x 3.25



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

102694

5.33

5.33

DJP  
07/07/09

2.3263

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>b50014</i>
<b>Description:</b> Rappel Anchor		<b>Part Number:</b> D2224
<b>Inspection Dwg:</b> D2224	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	0.185	✓			
0.050 x 45°	+/-0.010 x 0.5°	0.05 x 45°	✓			
0.250	+/-0.010	0.252	✓			
R0.500	+/-0.010	0.500	✓			
3.000	+/-0.010	3.003	✓			
Ø0.507	+0.008/-0.001	0.509	✓			
0.750	+/-0.010	0.750	✓			
2.313	+/-0.010	1.314	✓			
1.687	+/-0.010	1.685	✓			
2.438	+/-0.010	2.440	✓			
1.125	+/-0.010	1.124	✓			
Ø0.313	+0.006/-0.001	0.313	✓			

<b>Measured by:</b> <i>DJP</i>	<b>Audited by:</b> <i>S</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>09/07/06</i>	<b>Date:</b> <i>02/07/07</i>	<b>Date:</b>	N/A

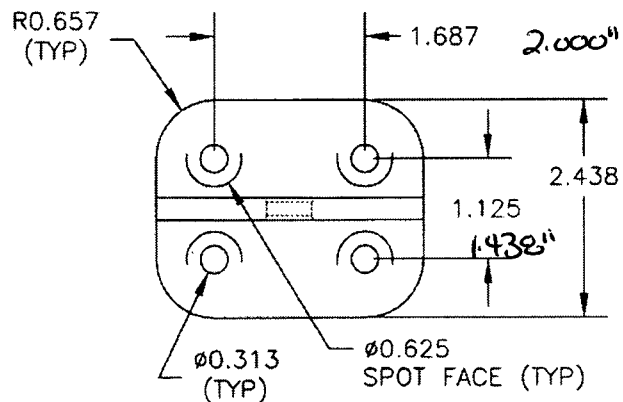
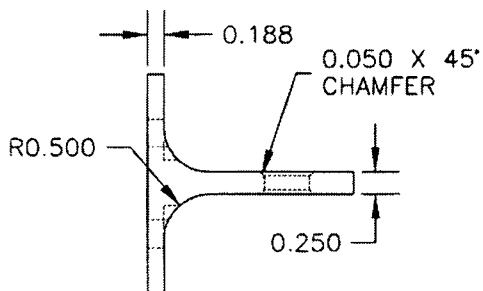
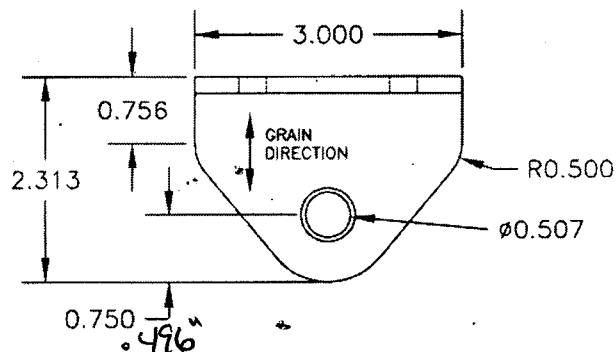
Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>



DESIGN <i>HA</i>	DRAWN BY <i>RI</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>HA</i>	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED  
99.04.29 KE

20-10-60  
H1025  
#52014



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)  
FINISH : ANODIZE RED PER MIL-A-8625  
BREAK ALL UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

76460

7/21/2009

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE****CERTIFICAT DE CONFORMITE****NO. DE COMMANDE:****PURCHASE ORDER/****PO10059**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	10	10	D2224 ✓ B50014	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
1	4	4	D2313 B40582	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

809/07/23

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: \_\_\_\_\_

\_\_\_\_\_  
[ ] Directeur de la Qualité / Q.A. Manager [ ]